

Date: Wednesday, 12/13/2006 2:41:36 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 29922D	
Estimate Number : 10356	
P.O. Number : <i>N/A</i>	Part Number : D2279
This Issue : 12/13/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2279 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : D
Previous Run : 28791D	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/5/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i> 061213	
Comment : Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2279
 Batch: *11101422* *M103028*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D 2279
 Dwg Rev: *D*
 Prog Rev: *D*

2-Deburr if necessary

*SAP 06:12:28**(20)**SAD 06:12:28*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 06:12:28**(20)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*07.01.02**(20)*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form As per Dwg D2279

*SAP 07-02-14**07.01.12**(20)**(20)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2279 PAR #: N/A Fault Category: Prod/Proc. Res ^{... need a. Savant.} NCR: Yes No DQA: Yes Date: 07/02/21
 QA: N/C Closed: Yes Date: 07.02.21

NCR: <u>29922D</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/28	2.0	wrong material size. 0.032 was used Scrap: replace with correct material. Human error.	<u>AS1042</u>	Replace parts with 0.040" mat'l. Destroy 0.032. Ensure to measure the mat'l before using it.	<u>SAB</u> <u>06/12/28</u>	<u>07-01-02</u>	<u>06-12-08</u> <u>AS1042</u>	<u>06-12-28</u>

NOTE: Date & initial all entries

Date: Wednesday, 12/13/2006 2:41:37 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 29922D

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



John.14 (20)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4/1 a.m.

07-02-19 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

167/2/19 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/02/19 (20)

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/21

Job Completion



11 07.02.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

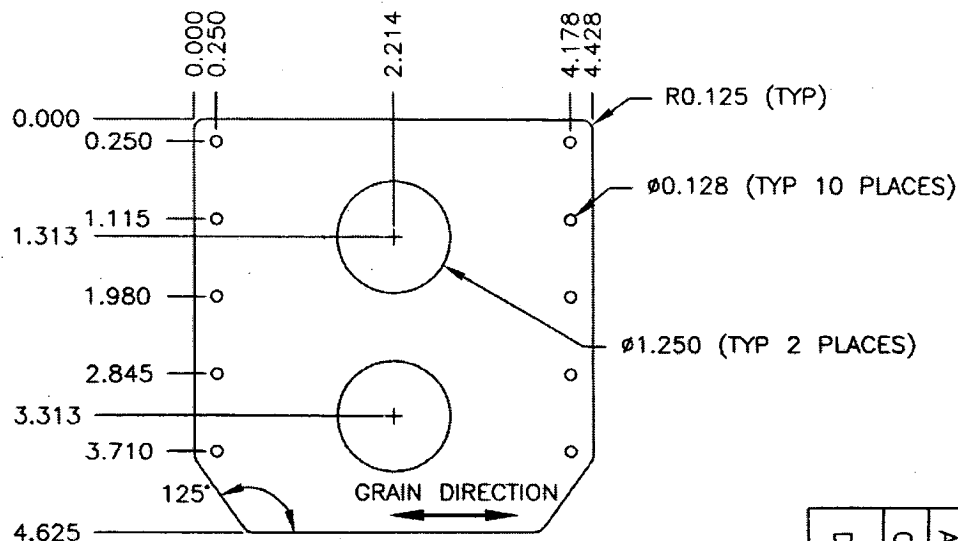
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

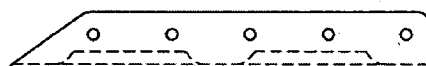
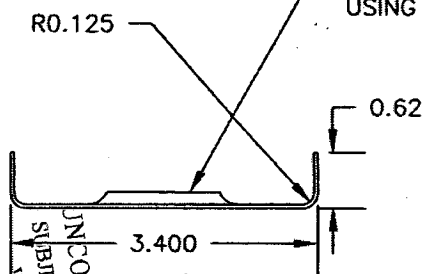
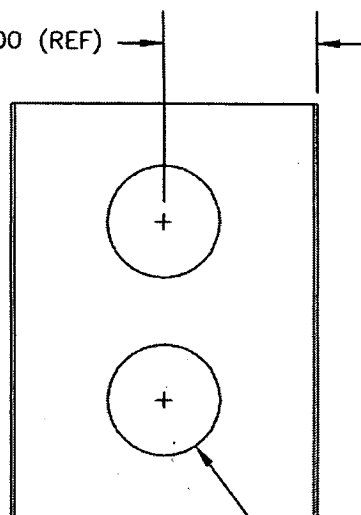


DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	REV. D
BW	CP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	KE	D2279	
DATE	TITLE	SCALE	
98.10.05	STEP SPACER	1:2	
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



FLAT LAYOUT

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



UNDER REVIEW

RELEASED
98.10.08 DS

DESIGN OK, BUT CHECK WITH
TS BEFORE MANUFACTURE

OK changes

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
2222

